

Work Order ID 63812

Monday, November 15, 2010 8:36:35 AM

Page 1

Item ID: D412-630-034

Accept

Setup Start

Revision ID:

Item Name: Heli Access Step RH Folding

Stop

Start Date: 11/15/2010 Start Qty: 2.00

Required Date: 11/22/2010 Req'd Qty: 2.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date: 10-11-15

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

IIN D412-630

Rev M

100

0.00



DC

Document Control

DOCUMENT CONTROL

Memo

Photocopy bluefile & create labels per PPP D412-630-034 CHG003

0.00

Subtotal

ck for BG 11/01/03

110

0.00



Small Fab

Small Fab

Small Fab

Memo

Assemble as per dwg D412-630 p.14 ☐ Coat all hardware with LPS3 rust inhibitor ☐ A/R LPS3 batch: M109927 ☐ COAT exposed HARDWARE WITH LPS PROCYON ☐ A/R LPS PROCYON BATCH: M114596

0.00

11/01/04 (2)

120

0.00



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

Subtotal

12/01/04

W/O: 63812		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
11/01/04	100	ADD Routing number to correct sequence	<i>[Signature]</i>	11.01.06			S 11/01/04

Part No: D412-630-034 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 63812

Monday, November 15, 2010 8:36:35 AM

Page 2

Item ID: D412-630-034

Accept

Setup Start

Revision ID:

Stop

Item Name: Heli Access Step RH Folding

Start Date: 11/15/2010 Start Qty: 2.00

Cust Item ID:

Required Date: 11/22/2010 Req'd Qty: 2.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

11/21/29 2

140

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

Subtotal

x2
RH

150

Packaging

0.00



Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D412-630

034 Location: 110 PPP Rev: 2

11/21/29 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 63812

Page 3

Monday, November 15, 2010 8:36:35 AM

Item ID: D412-630-034

Accept



Setup Start



Revision ID:

Item Name: Heli Access Step RH Folding

Stop



Start Date: 11/15/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 11/22/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

CK 11/01/07

MF
11-01-08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Picklist Print

Monday, November 15, 2010 8:36:40 AM

Page 1

Work Order ID: 63812

Parent Item: D412-630-034

Parent Item Name: Heli Access Step RH Folding

Start Date: 11/15/2010

Required Date: 11/22/2010

Start Qty: 2.00

Required Qty: 2.00


Comments: IPP Rev:A New Issue 06-11-08 JLM
IPP rev B ecn1019, added D2807-041 EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

AN310C8  Nut		Purchased	No				Each	31.0000	2	4		10/12/29SP	
---	--	-----------	----	--	--	--	------	---------	---	---	--	------------	--

Location	Loc Qty	Loc Code
----------	---------	----------

ST324	31	
109148	1	
111819	30	

AN3C21A  BOLT		Purchased	No				Each	56.0000	2	4		10/12/29SP	
--	--	-----------	----	--	--	--	------	---------	---	---	--	------------	--

Location	Loc Qty	Loc Code
----------	---------	----------

ST352	56	
109148	56	

52 AN44C7A  Eyebolt		Purchased	No			#B30	Each	88.0000	1	2		10/12/29SP 20	
--	--	-----------	----	--	--	------	------	---------	---	---	--	---------------	--

Location	Loc Qty	Loc Code
----------	---------	----------

ST362	88	
109013	47	
111308	40	
111503	1	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Picklist Print

Monday, November 15, 2010 8:36:40 AM

Page 2

Work Order ID: 63812

Parent Item: D412-630-034

Parent Item Name: Heil Access - top RH Folding

Start Date: 11/15/2010

Required Date: 11/22/2010

Start Qty: 2.00

Required Qty: 2.00

AN4C10A

Purchased No

#130

Each

116.0000



2
10/12/29

Bolt

Location

Loc Qty

Loc Code

ST356

116

106302

5

111295

31

112243

50

114523

30

2

AN4C15A

Purchased No

#130

Each

167.0000



4
10/12/29

Bolt

Location

Loc Qty

Loc Code

ST358

167

115835

67

115936

100

2

AN4C6A

Purchased No

#130

Each

517.0000



2
10/12/29

Bolt

Location

Loc Qty

Loc Code

FG

4

103344

4

ST356

513

113121

63

115016

200

116003

200

116075

50

2

Monday, November 15, 2010 8:36:40 AM

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Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

Monday, November 15, 2010 8:36:40 AM

Page 3

Work Order ID: 63812

Parent Item: D412-630-034

Parent Item Name: Heli Access. Step RH Folding

Start Date: 11/15/2010

Required Date: 11/22/2010

Start Qty: 2.00

Required Qty: 2.00

AN5C15A

Purchased

No

#130

Each

78.0000

2

4

10/12/29 sf



Bolt

Location

Loc Qty

Loc Code

ST339

78

111819

78

AN8C16

Purchased

No

Each

75.0000

2

4

10/12/29 sf



Bolt

Location

Loc Qty

Loc Code

ST345

75

105969

15

106066

60

D2012-107

Manufactured

No

Each

28.0000

1

2

10/12/29 sf



Clevis

Location

Loc Qty

Loc Code

ST004

28

46634

2

62242

26

D2803-042

Manufactured

No

Each

5.0000

1

2

10/12/29 sf (2)



Bracket Assembly

Location

Loc Qty

Loc Code

ST149

5

61725

3

62073

2

Monday, November 15, 2010 8:36:40 AM

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Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Picklist Print

Monday, November 15, 2010 8:36:40 AM

Page 4

Work Order ID: 63812

Parent Item: D412-630-034

Parent Item Name: Heli Access Step RH Folding

Start Date: 11/15/2010

Required Date: 11/22/2010

Start Qty: 2.00

Required Qty: 2.00

D2804-042

Manufactured No

Each

6.0000

1

2



Bracket Assembly



10/12/29 sf

Location

Loc Qty

Loc Code

ST150

6

61727

2

62077

4

2

D2806-1

Manufactured No

Each

15.0000

2

4



Bushing



10/12/29 sf

Location

Loc Qty

Loc Code

ST025

15

46609

15

4

D2806-3

Manufactured No

Each

15.0000

2

4



Bushing



10/12/29 sf

Location

Loc Qty

Loc Code

ST025

15

46737

15

4

D2807-041

Manufactured No

Each

23.0000

2

4



Door prop



10/12/29 sf

20

Location

Loc Qty

Loc Code

ST023

23

60540

2

60771

1

61891

20

4

Monday, November 15, 2010 8:36:40 AM

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Page 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Monday, November 15, 2010 8:36:40 AM

Page 5

Work Order ID: 63812

Parent Item: D412-630-034

Parent Item Name: Heli Access Step RH Folding

Start Date: 11/15/2010

Required Date: 11/22/2010

Start Qty: 2.00

Required Qty: 2.00

D2810-5 Manufactured No



Sp2 Strut

#130

Each 6.0000



2 10/12/29 SP

Location

Loc Qty

Loc Code

ST265

6

52034

6

2

D2813 Manufactured No



Washer

Each

35.0000



4 10/12/29 SP

Location

Loc Qty

Loc Code

ST025

35

61051

35

4

D3395-1 Manufactured No



Bushing

Each

44.0000



8 10/12/29 SP

Location

Loc Qty

Loc Code

ST052

40

60861

40

8

ST055

4

46616

4

4

D3396-1 Manufactured No



Spacer

#130

Each

48.0000



4 10/12/29 SP (2x)

Location

Loc Qty

Loc Code

ST055

48

46748

48

0

Monday, November 15, 2010 8:36:40 AM

Shop Packet Print

Page 5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Monday, November 15, 2010 8:36:40 AM

Page 6

Work Order ID: 63812

Parent Item: D412-630-034

Parent Item Name: Her Access Step RH Folding

Start Date: 11/15/2010

Required Date: 11/22/2010

Start Qty: 2.00

Required Qty: 2.00

D3562-042 Manufactured No

Each 1.0000

1 2



Step Assembly, RH



64096

[Signature]

Location

Loc Qty

Loc Code

FG110

1

54964

1

MS21043-3 Purchased No

Each 2,360.000

4

8



Nut



10/12/29SL

Location

Loc Qty

Loc Code

FG

76

103691

76

ST301

2284

112314

2284

MS21043-4 Purchased No

Each 774.0000

41

8



Nut



10/12/29SL

[Signature]

Location

Loc Qty

Loc Code

FG

40

104603

40

ST301

734

112492

25

113069

8

114523

101

114784

300

115936

300

8

Monday, November 15, 2010 8:36:40 AM

Shop Packet Print

Page 6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Monday, November 15, 2010 8:36:40 AM

Page 7

Work Order ID: 63812

Parent Item: D412-630-034

Parent Item Name: Heli Access Step RH Folding

Start Date: 11/15/2010

Required Date: 11/22/2010

Start Qty: 2.00

Required Qty: 2.00

MS21043-5 Purchased No

Each 568.0000

3

6



10/12/29

Nut

Location

Loc Qty

Loc Code

ST301

568

111819

68

112314

500

MS24665-302

Purchased No

Each 43.0000

2

4



10/12/29

Cotter Pin

Location

Loc Qty

Loc Code

ST309

43

113644

43

MS24693-C280

Purchased No

Each 49.0000

2

4



10/12/29

Screw

Location

Loc Qty

Loc Code

ST310

30

115594

30

ST318

19

111279

19

NAS1515H3

Purchased No

Each 186.0000

6

12



10/12/29

Washer

Location

Loc Qty

Loc Code

ST277

186

111268

4

115675

82

115935

100

12

Monday, November 15, 2010 8:36:40 AM

Shop Packet Print

Page 7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector.

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Monday, November 15, 2010 8:36:40 AM

Page 8

Work Order ID: 63812

Parent Item: D412-630-034

Parent Item Name: Heli Access Step RH Folding

Start Date: 11/15/2010

Required Date: 11/22/2010

Start Qty: 2.00

Required Qty: 2.00

NAS1515H4

Purchased No

#130

Each

87.0000

7

14



Washer



10/12/29sf

Location

Loc Qty

Loc Code

ST277

87

111294

5

111525

82

Each

212.0000

7

14

NAS1515H5

Purchased No

#130



Washer



10/12/29sf

Location

Loc Qty

Loc Code

FG

44

103286

17

103691

27

ST277

168

109430

168

Each

140.0000

4

8

NAS1515H5L

Purchased No



WASHER



10/12/29sf (22)

Location

Loc Qty

Loc Code

FG

40

103691

40

ST277

100

108964

12

111359

88

4

2

Monday, November 15, 2010 8:36:40 AM

Shop Packet Print

Page 8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Monday, November 15, 2010 8:35:40 AM

Page 9

Work Order ID: 63812

Parent Item: D412-630-034

Parent Item Name: Feli Access Step RH Folding



Start Date: 11/15/2010

Required Date: 11/22/2010

Start Qty: 2.00

Required Qty: 2.00

NAS1515H8

Purchased

No

Each

322.0000

4

8



Washer



11/22/2010

Location

Loc Qty

Loc Code

ST278

322

111275

122

111411

200

8

Monday, November 15, 2010 8:36:40 AM

Shop Packet Print

Page 9

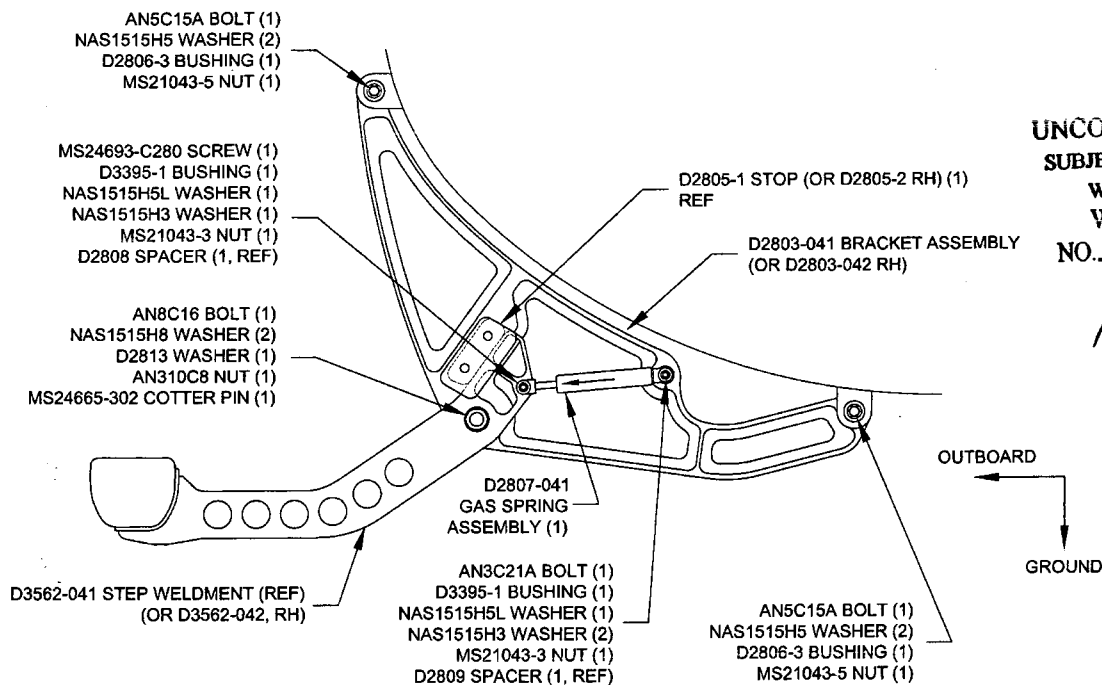
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

D412-630-033/-034 Heli-Access-Step™ Installation

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 63812
DA10-11-15

FIGURE 14 – STA 84.29 for D412-630-033/-034 Heli-Access-Step™ Installation
(View rotated 90° CW)

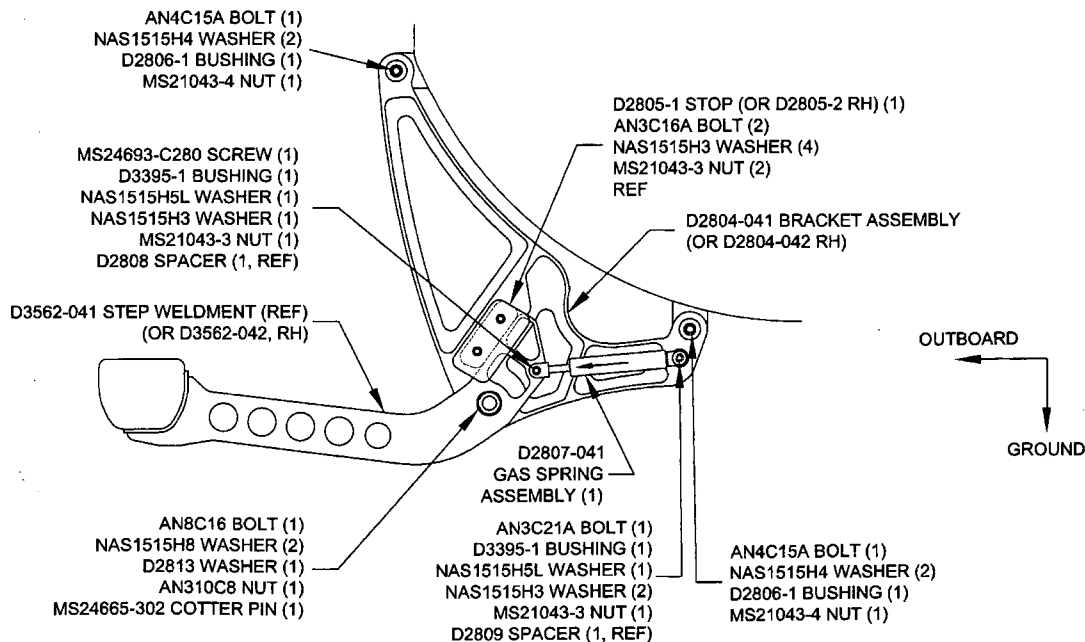


FIGURE 15 – STA 155.06 for D412-630-033/-034 Heli-Access-Step™ Installation
(View rotated 90° CW)

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Revision: **M**
Date: 08.12.12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Qty -033	Qty -034	Qty -243	Qty -244	Part Number	Description
X				D412-630-033	HELI-ACCESS-STEP™ LH (FOLDING)
	X			D412-630-034	HELI-ACCESS-STEP™ RH (FOLDING)
1		X		D412-630-243	STEP ASSEMBLY LH
	1		X	D412-630-244	STEP ASSEMBLY RH
		1	1	D2012-107	CLEVIS
		1		D2803-041	STA 84 BRACKET ASSEMBLY LH
			1	D2803-042	STA 84 BRACKET ASSEMBLY RH
		1		D2804-041	STA 155 BRACKET ASSEMBLY LH
			1	D2804-042	STA 155 BRACKET ASSEMBLY RH
2	2			D2806-1	BUSHING
2	2			D2806-3	BUSHING
		2	2	D2807-041	GAS SPRING ASSEMBLY (WAS D2807)
1	1			D2810-5	STRUT
		2	2	D2813	WASHER
		1		D3562-041	STEP WELDMENT LH
			1	D3562-042	STEP WELDMENT RH
		4	4	D3395-1	BUSHING
2	2			D3396-1	SPACER
		2	2	AN3C21A	BOLT
1	1			AN4C6A	BOLT
1	1			AN4C10A	BOLT
2	2			AN4C15A	BOLT
1	1			AN44-C7A	EYEBOLT
2	2			AN5C15A	BOLT
		2	2	AN8C16	BOLT
		2	2	AN310C8	NUT
		2	2	MS24665-302	COTTER PIN (OR AN380C3-4)
		6	6	NAS1515H3	WASHER
7	7			NAS1515H4	WASHER
7	7			NAS1515H5	WASHER
		4	4	NAS1515H5L	WASHER
		4	4	NAS1515H8	WASHER
		4	4	MS21043-3	NUT
4	4			MS21043-4	NUT
3	3			MS21043-5	NUT
		2	2	MS24693-C280	SCREW (OR MS24694-C565)